

Date: Thursday, 17/04/2008 10:59:30 AM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|----------------------------------|---------------------------------------|--|---------------------|-------------------------|--------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : FWD X-TUBE | | |
| Job Number | : 38665 | | | | | |
| Estimate Number | : 10006 | | | | | |
| P.O. Number | : | | | Part Number | : D2889 | |
| This Issue | : 17/04/2008 | | S.O. No. | : D2889 REV B | | |
| Prsht Rev. | : NC | | | Project Number | : N/A | |
| First Issue | : / / | | Type | : LANDING GEAR | | |
| Previous Run | : 38664 | | | Drawing Revision | : B | |
| Written By | : | | | Material | : | |
| Checked & Approved By | <u>JLD 08-4-17</u> | | | Due Date | : 30/05/2008 | |
| Comment | : Est Rev:A New Issue 05-10-25 JLM | | | Qty: | 1 | Um: Each |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|------------------------------|
| 1.0 | D6005180 | Crosstube Material |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube <u>B38345 DP88-12</u> | | |
| 2.0 BENDING BENDING MACHINE - SKIDTUBES Comment: LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001 <u>DP88-12</u> | | |
| 3.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
| Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish <u>N/A</u> | | |
| 4.0 | QC15 | DIMENSIONAL CHECK OF X-TUBES |
| Comment: DIMENSIONAL CHECK OF X-TUBES <u>0808-12 O</u> | | |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube <u>N/A</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/04/2008 10:59:30 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38665

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U10 37906 (-101)

08-08-12 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/08/14
MF 08-08-13

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr |
| | | | | | | |
| | | | | | | |

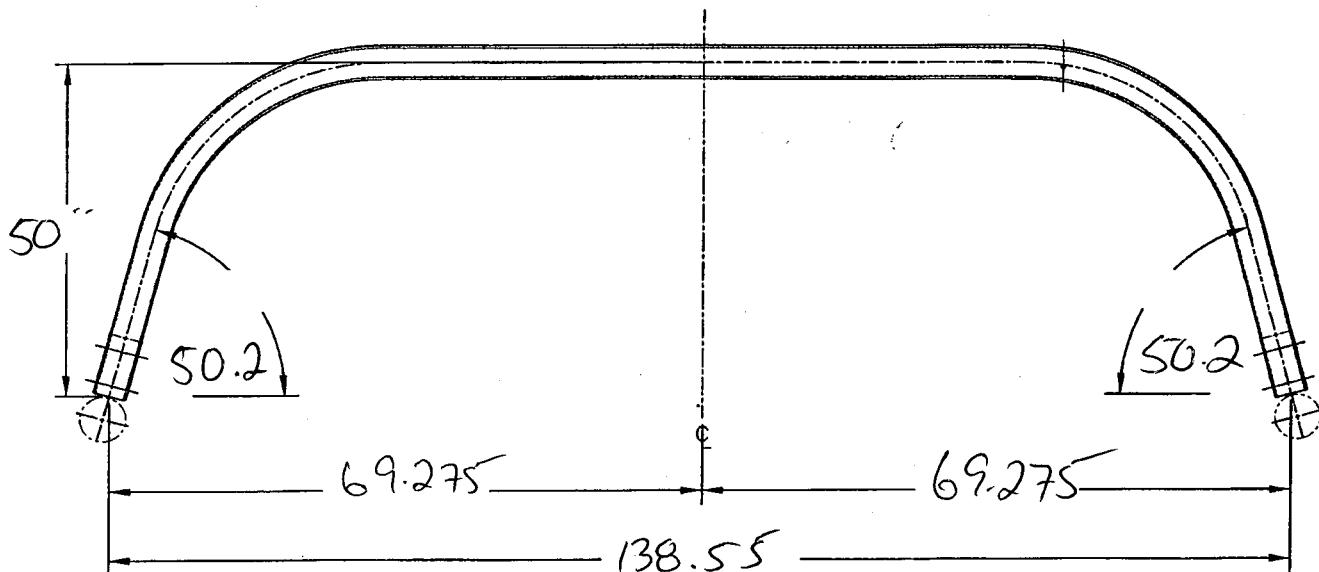
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|----------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 38665 |
| Description: Crosstube Fwd | Part Number: | D2889 |
| Inspection Dwg: D2889 | Rev: B | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 49.875 | 50.125 |
| 1/2 Span | 69.275 | 69.525 |
| Angle | 49 | 52 |
| Total Span | 138.55 | 139.05 |



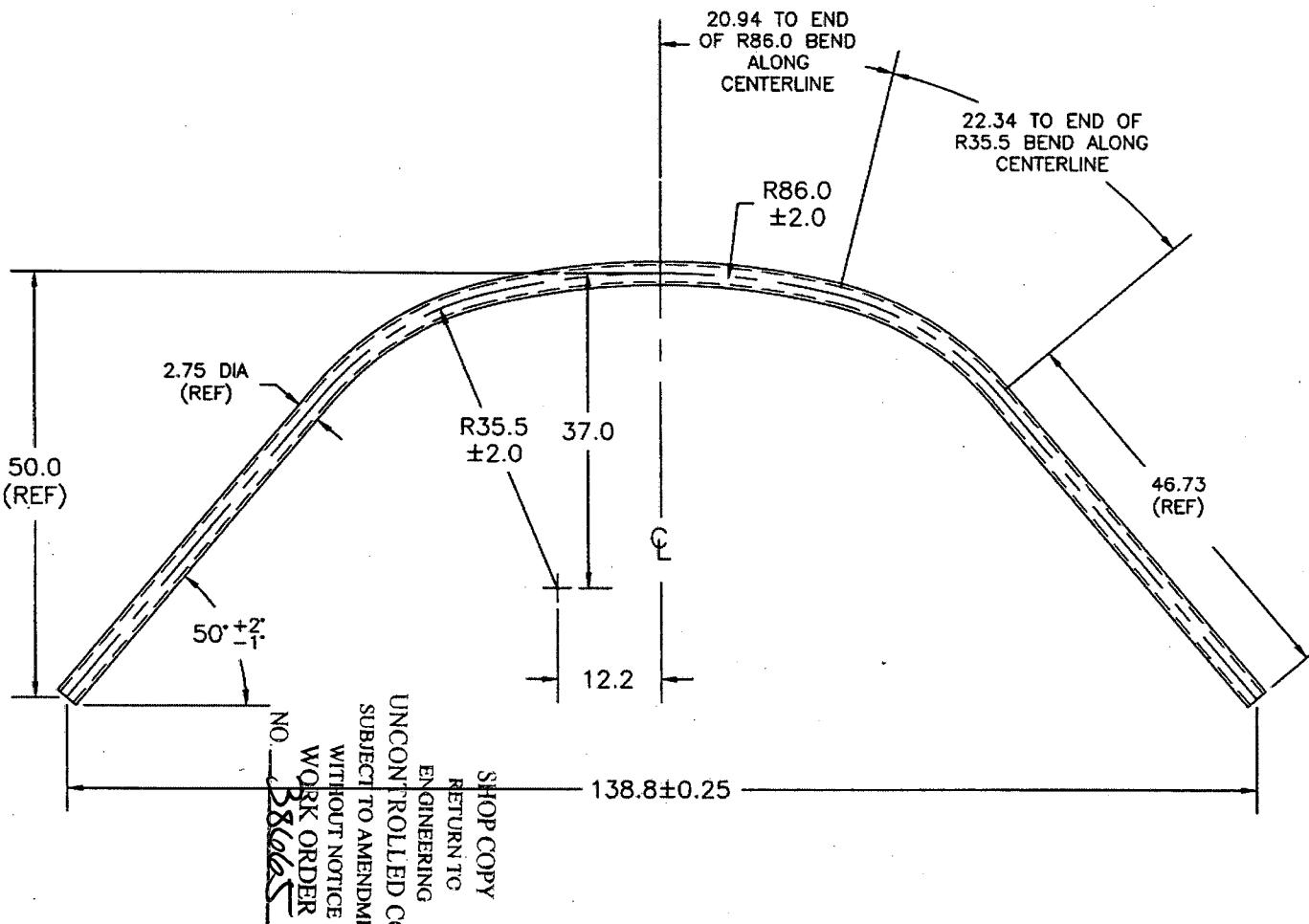
| Comments |
|----------|
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|-----------------|----------|
| QC15 Inspection | |
| Date | 08/08/12 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | JM |

DART**RELEASED**
02.10.28

| DESIGN | DRAWN BY | DART AEROSPACE LTD | | |
|----------|----------|-----------------------------|-----------------------------------|-------|
| | | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | APPROVED | DRAWING NO. | REV. B | |
| DATE | | | SHEET 1 OF 1 | SCALE |
| 02.10.18 | | D2889 | | 1:20 |
| A | | 99.05.21 | NEW ISSUE | |
| B | | 02.10.18 | ADD TANGENT LENGTHS; CHANGE NOTES | |



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 386as

SHOP COPY
RETURN TO
ENGINEERING

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.